

Work Order ID 78224-2

January-02-12 3:51:04 PM

78224

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Item ID: D3937-041

Revision ID:

Item Name: Luminescent Strip Assembly

Start Date: 02/01/2012 Start Qty: 64.00

Required Date: 16/01/2012 Req'd Qty: 64.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.S

QC:

Date: 12/01/12 Tooling:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3937

B

100

0.00

100

Shear

Shear

Memo

1-Cut as per Dwg D3937 (Make D3937-3)
Dwg Rev: 13

2-Deburr if necessary

0.00

0.00

0.00

0.00

0.00

110

110

QC

Quality Control

QC2-Inspect parts off machine F/AI/FAB

Memo

120

120

QC

Quality Control

QC8-Inspect parts - second check

Memo

Split

18

64

64

SS

12-01-2012

N/A

12-2-25

QC5

12-01-2012 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78224

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Item ID: D3937-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Luminescent Strip Assembly

Start Date: 02/01/2012 Start Qty: 64.00

64

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 64.00

64

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

66 BK 12-1-25

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

66 d 12/01/12

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Align part edges and stick strip to D3937-3 as per dwg

\$ 10x 12-01-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-01-31	150	Stock balance of D3937-3 using same B/N				u 12-01-31		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 78224

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Item ID: D3937-041

Revision ID:

Item Name: Luminescent Strip Assembly

Start Date: 02/01/2012 Start Qty: 64.00

Required Date: 16/01/2012 Req'd Qty: 64.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/2/12

(18)

170

Identify as per dwg & Stock Location **ST 72**

0.00

170

Packaging

Memo

0.00

Packaging

(18) SP 12-01-31

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/2/12

PL 12-01-31 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78224

Parent Item: D3937-041

Parent Item Name: Luminescent Strip Assembly

78224

D3937-041

Start Date: 02/01/2012

Required Date: 16/01/2012

Start Qty: 64.00

Required Qty: 64.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3937-1

Manufactured No

Each 3.0000

64

D3937-1

Luminescent Strip

**

SS 12/01/30

Location

Loc Qty

Loc Code

ST094

3

78226

73537

3

18

M6061T6S.032

Purchased

No

100

sf

68.8840

0.09099

6.129853

M6061T6S.032

6061-T6 Sheet 0.032"

**

FF 12/01-24

Location

Loc Qty

Loc Code

MAT021

68.884

118106

68.384

16954

0.5

M 12/01/30

12/01/30

3

12/01/30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

PEEL SELF-ADHESIVE BACKING FROM
D3937-1 LUMINESCENT STRIP.
ALIGN PART EDGES AND STICK TO
D3937-3 SHEET METAL BACKING STRIP

D3937-041 LUMINESCENT STRIP ASSEMBLY

RELEASED
2009-12-02
ND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

B	SHEET 2 SPEC CHART LENGTH WAS 21.0. SHEET 3 ZONE CS 19.5 DIM WAS 21.0 REASON: PREVENT EXCESSIVE WASTE.		AJS	09.11.27
A	NEW ISSUE		BY	09.06.02
REV	DESCRIPTION			
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		DESIGN NO.	REV. B
CHECKED	AJS		D3937	SHEET 1 OF 3
MFG. APPR.	AJS		TITLE	SCALE
APPROVED	AJS		LUMINESCENT STRIP	NTS
DE APPR.	AJS		COPYRIGHT © 2000 BY DART AEROSPACE LTD THE DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OF COPYRIGHT OR UNLAWFUL REPRODUCTION WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.11.27			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

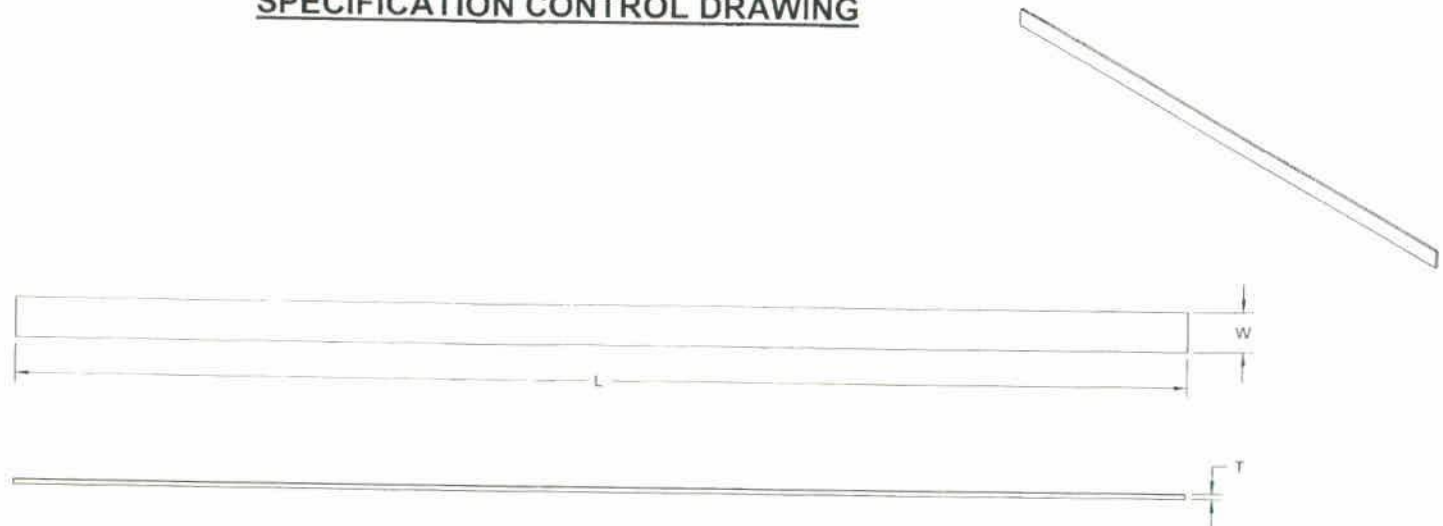
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

78224

SPECIFICATION CONTROL DRAWING



D3937-1 LUMINESCENT STRIP

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	19.5	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS



RELEASED
2009-12-02

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE TABLE

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3937	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

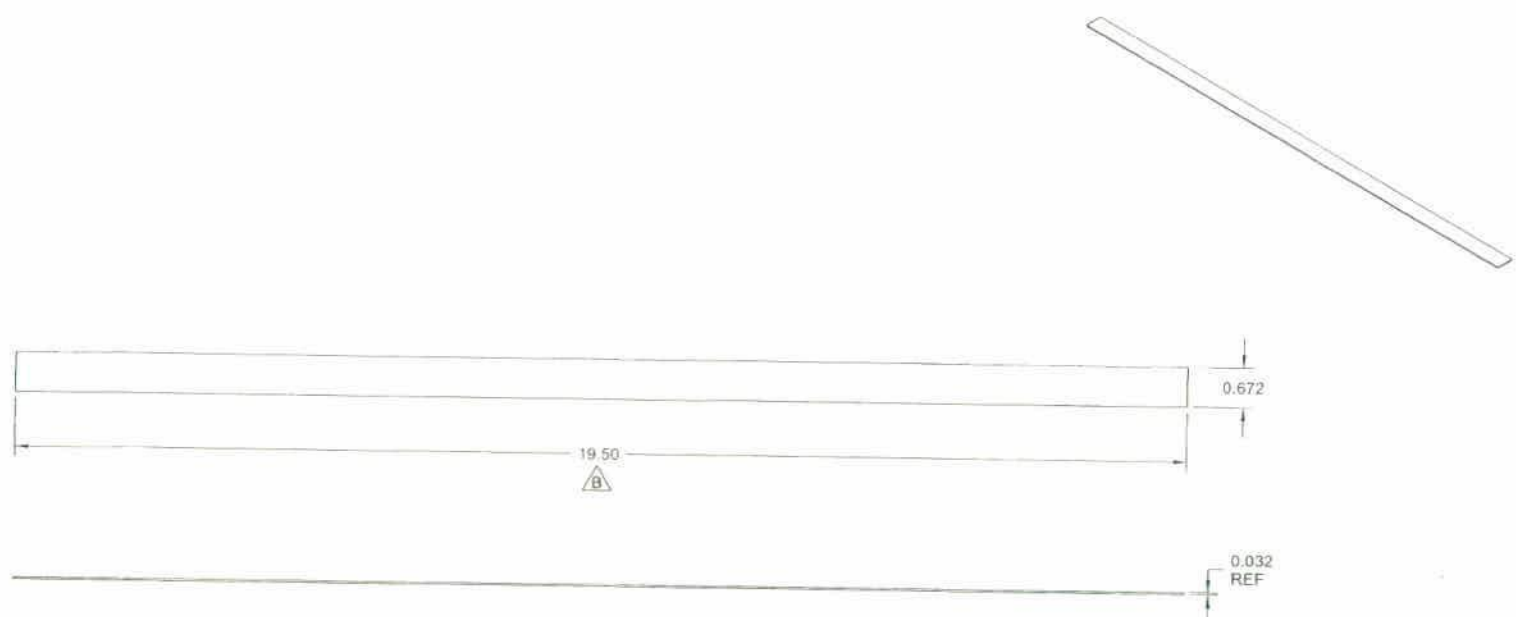
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

70224



D3937-3 SHEET METAL BACKING STRIP

RELEASED
2009-12-02

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV B
MFG. APPR.		D3937	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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